

Date: Friday, 12/7/2007 10:20:50 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT CAP
Job Number	: 36184		
Estimate Number	: 10312		
P.O. Number	: N/A	Part Number	: D2646
This Issue	: 12/7/2007 S.O. No. : N/A	Drawing Number	: D2646 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: C
Previous Run	: 33289	Material	: N/A
Written By	: <u> </u>	Due Date	: 12/24/2007
Checked & Approved By	: <u> </u>	Qty:	50 Um: Each
Comment	: Est: G 05.08.22 Hole size revised in Step 5 KJ/JLM		
	Est Rev: H Changed Inserts 07-02-19 JLM		
	est rev I changed inserts 07.06.11 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 5243

C 207112110

(50)

1-Spin as per Dwg D2646

2-Material release note required

2.0	D2646P	Aft Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)
 AFT CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

C 7/12/19

(50)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2646

C 7/12/24

(50)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill using DT8026 as per Dwg D2646.

2-Open holes to .297 as per Dwg D2646.

SAD 07-12-27 549

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D36184 ²⁶⁴⁶ PAR #: N/A Fault Category: Prod / ~~Prod~~ ^{med & small} NCR: Yes No DQA: 2 Date: 08.01.08
 QA: N/C Closed: 4 Date: 08.01.08

NCR: <u>36184</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07-12-27</u>	<u>5.0</u>	<u>1 part scrap. 4 holes drilled in the cap. RC: Human error</u>	<u>[Signature]</u> <u>QSIWZ</u>	<u>Scrap: destroy</u>	<u>SAH</u> <u>07-12-27</u>	<u>[Signature]</u> <u>07-12-27</u>	<u>[Signature]</u> <u>QSIWZ</u>	<u>[Signature]</u> <u>07-12-27</u>

NOTE: Date & initial all entries

Date: Friday, 12/7/2007 10:20:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 36184

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Deburr

6.0

QC5

INSPECT WORK TO CURRENT STEP



12-27 (49)

Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 08-01-04

(49)

8.0

POWDER COATING

POWDER COATING



M106379

(49X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1 08/01/05

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-07

(49)

10.0

ALS71032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s)

INSERT

Batch:

M105729

M-1 08/02/07

(49X)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

M-1 08/01/07

(49X)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/07 (49)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-17

M-1 08/01/07

(49X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/7/2007 10:20:51 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 36184

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



49

Comment: FINAL INSPECTION/W/O RELEASE

2008/01/08

Job Completion



2008/1/18

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

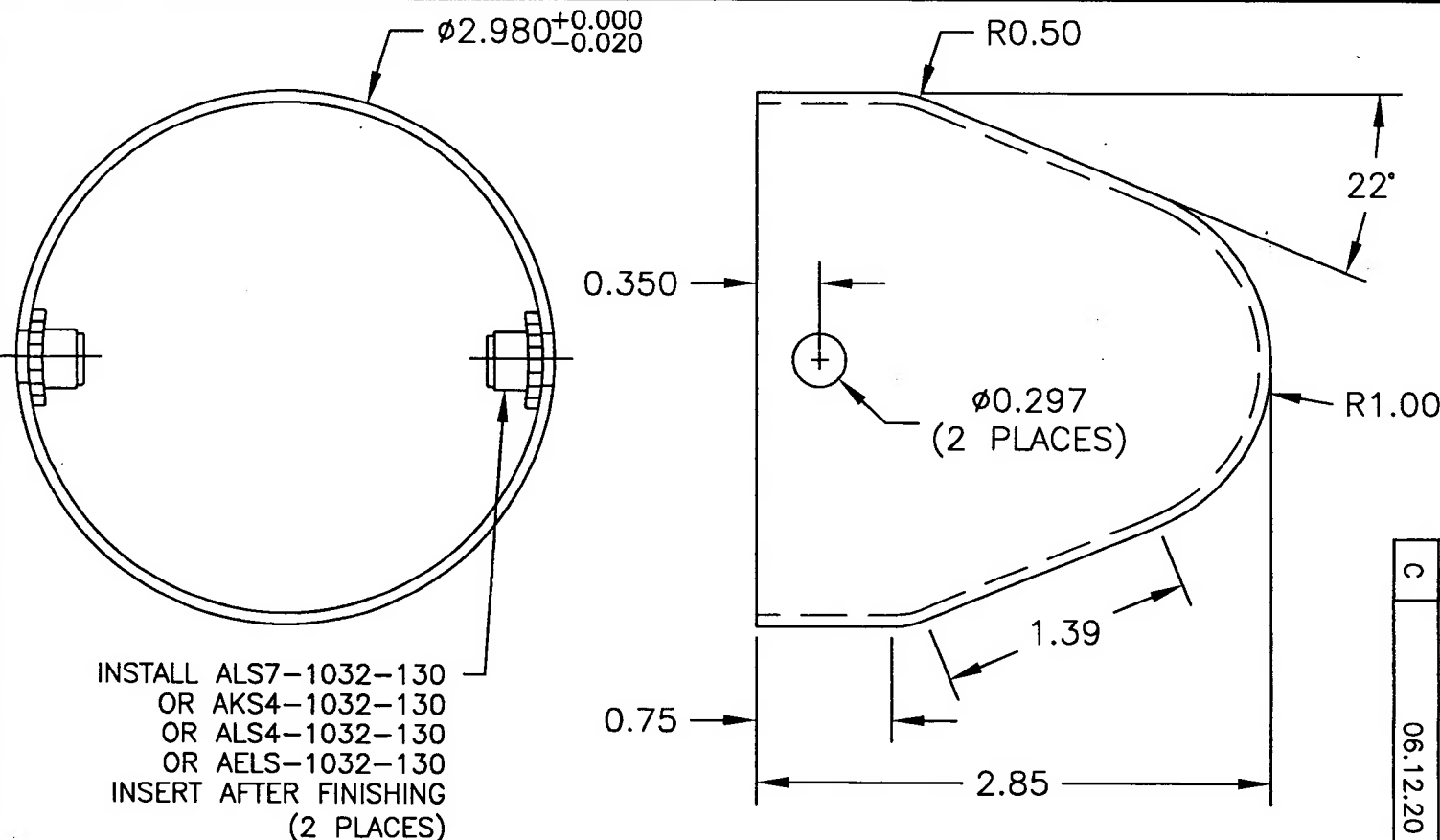
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DS	DRAWN BY	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. C
CHECKED	<i>[Signature]</i>	APPROVED	D2646	SHEET 1 OF 1	
DATE	06.12.20	TITLE	AFT CAP	SCALE	1:1
A	97.03.25	NEW ISSUE			
B	05.04.01	CHANGE TO CLOSED INSERTS			
C	06.12.20	CHANGE TO OPEN ENDED INSERTS			



D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36184

RELEASED
07.02.02



Sieg's Manufacturing Ltd.
6236 205 street, Langley BC, V2Y 1N7
Phone: (604) 530-7455 Fax: (604) 530-7490

Packing Slip

Packing Slip No.:

34753

Date:

12/18/2007

Page:

1

Sold to:	Ship to:
DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7
Order No.: 5243	Sold By: KAULBARS, KALE
Shipped By:	Ship Date: 12/18/2007
Tracking No.:	

Item No.	Unit	Description	Quantity
1	EACH	AFT CAPS D2646P	50
Comment:			

ALCON WITH UTODICS
1480 Muhlen Pkge
Lancaster Pa 17601

Certification of Test Results

P/N 970200

PO 382880

SOLD TO

SHIP TO

CERT NO 1000875096
DATE 4/23/2007
SKID NO 661032
SKID WGT 5,885
PAGE 1 OF 1

ORDER NO	LG5947	PO NO	43-62756			MILL FINISH	
ITEM NO	1	PART NO				NOM ANODIZE QUALITY	
ALLOY	1100	TEMPER	O	FORM	COIL	OUT: STANDARD MILL FINISH	
GAUGE	05300	WIDTH	48.0000	LENGTH	0.0000	IN: STANDARD MILL FINISH	
						NOT EMBOSSED	

LOT: 034171 COIL: B01 DROP: 0776187

LOT: 334171 COIL: B02 DROP: 07TG187

INGOT	SI	FE	CU	NI	MG	CR	NT	AN	TI
0018321	0.12	0.40	0.12	0.02	0.01	0.01	0.01	0.01	0.01
HEAD ELEMENTS: 0018321									

HEAD ULTIMATE STRENGTH 13.1 KSI
TAIL ULTIMATE STRENGTH 13.0 KSI
HEAD YIELD STRENGTH (OFFSET) = 12.4 KSI
TAIL YIELD STRENGTH (OFFSET) = 12.4 KSI
HEAD ELONGATION (5 L. = 2 IN) 3.5 %
TAIL ELONGATION (5 L. = 2 IN) 3.5 %

* AS REPORTED BY SUPPLIER
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-05

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF
ASME SPEC 1102 C, AMS 1011H 100 C,
ASTM B209-95 1100 C, AMS-70 A 350% 1100
FAX CENTER 714 786-4840

• END OF CONFERENCE •

Manufacture of certain goods otherwise than in the manner specified in the conditions is prohibited, imposed, and listed in accordance with the method and been found to be the application of the samples described hereon, including the said items forming a part of the description of a particular manufacturing or manufacturing process, and the method of manufacture, and the method of manufacture of the goods. Confidentiality of the goods is not to be reproduced except in full.

100% KODAK SAFETY FILM

Sold to: COPPER & BRASS SALES PO: 38C380 Part: Order No.: 376275
 TR clerk signature Date: 12/1/75



Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7
TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: DEC. 18/07
Customer: DART AEROSPACE
Packing Slip: 34753

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By
<u>D2646P</u>	<u>50</u>	<u>14G 1100</u>	<u>N/A</u>	<u>✓</u>	<u>[Signature]</u>

Notes:

LOOKED GOOD TO ME. THE SPECS ARE
THE SAME THIS TIME BUT I HAVE NEW ONES
FOR NEXT TIME.

THANK YOU

Material Certification Attached: Yes